

Work Order ID 85116

85116

ASAP

Page 1

Friday, June 01, 2012 4:05:21 PM

Item ID: PB67-43001-75

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Upper Blade Support Ass'y

Start Date: 6/1/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *ME*

Date: *12-06-04* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

B67-43001-75

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg PB67-43001

2 - \$

fl
12-06-12

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

2 - \$

fl
12-06-15

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

S. Becker

fl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

1- put screws in nut plates before to keep thread clean
START TIME: 2-30 OVEN TEMPERATURE:

FINISH TIME: 3-00

2X Ø

MZ
12/06/18

W18144

3200F

3-00

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

2 Ø

BR 12-6-18

150

Identify as per dwg & Stock Location: W14

0.00

150

Packaging

Memo

0.00

Packaging

2 Ø

12-06-19

W/O:		WORK ORDER CHANGES					
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Stop ***NS2***

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2

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/6/2012

MF
12-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, June 01, 2012 4:05:20 PM

Page 1

Work Order ID: 85116

Parent Item: PB67-43001-75

Parent Item Name: Upper Blade Support Ass'y

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:ec IPP rev B 10.09.30 per rev C
dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3450-1 Reinforcement Plate		Manufactured	No			100	Each	7.0000	1	2		12.06.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST440		7							
				53302		7				2			
PB67-43001-167 Side Plate		Manufactured	No			100	Each	8.0000	2	4		12.06.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST446A		8							
				55039		8				4			
PB67-43001-169 Long Support Plate		Manufactured	No			100	Each	0.0000	1	2		12.06.12	
PB67-43001-171 Mounting Plate		Manufactured	No			100	Each	16.0000	6	12		12.06.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST446A		16							
				41563		16				12			

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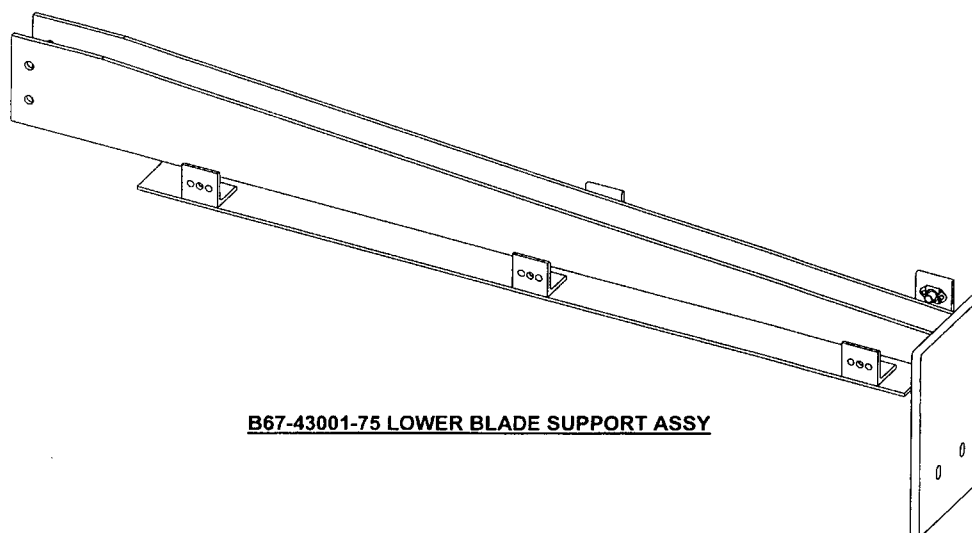
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8 7 6 5 4 3 2 1

ITEM	QTY -75	P/N	DESCRIPTION
1	X	B67-43001-75	LOWER BLADE SUPPORT ASSY
3	2	B67-43001-167	SIDE PLATE
4	1	B67-43001-169	LONG SUPPORT PLATE
5	6	B67-43001-171	MOUNTING PLATE
6	1	D3450-1	REINFORCEMENT PLATE
8	12	MS20426AD3-4	RIVET
9	6	MS21075L3	NUT PLATE



B67-43001-75 LOWER BLADE SUPPORT ASSY

#85116

RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREEN SANDEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-75" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.20 lbs
- 8) WELDING: PER DART QSI 004

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.26
REV.	DESCRIPTION		BY	DATE
DESIGN	R/V	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.	AS	B67-43001-75	SHEET 1 OF 2	
APPROVED	MP	TITLE	SCALE	
DE APPR.	N/A	LOWER BLADE SUPPORT ASSY	NTS	
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8 7 6 5 4 3 2 1

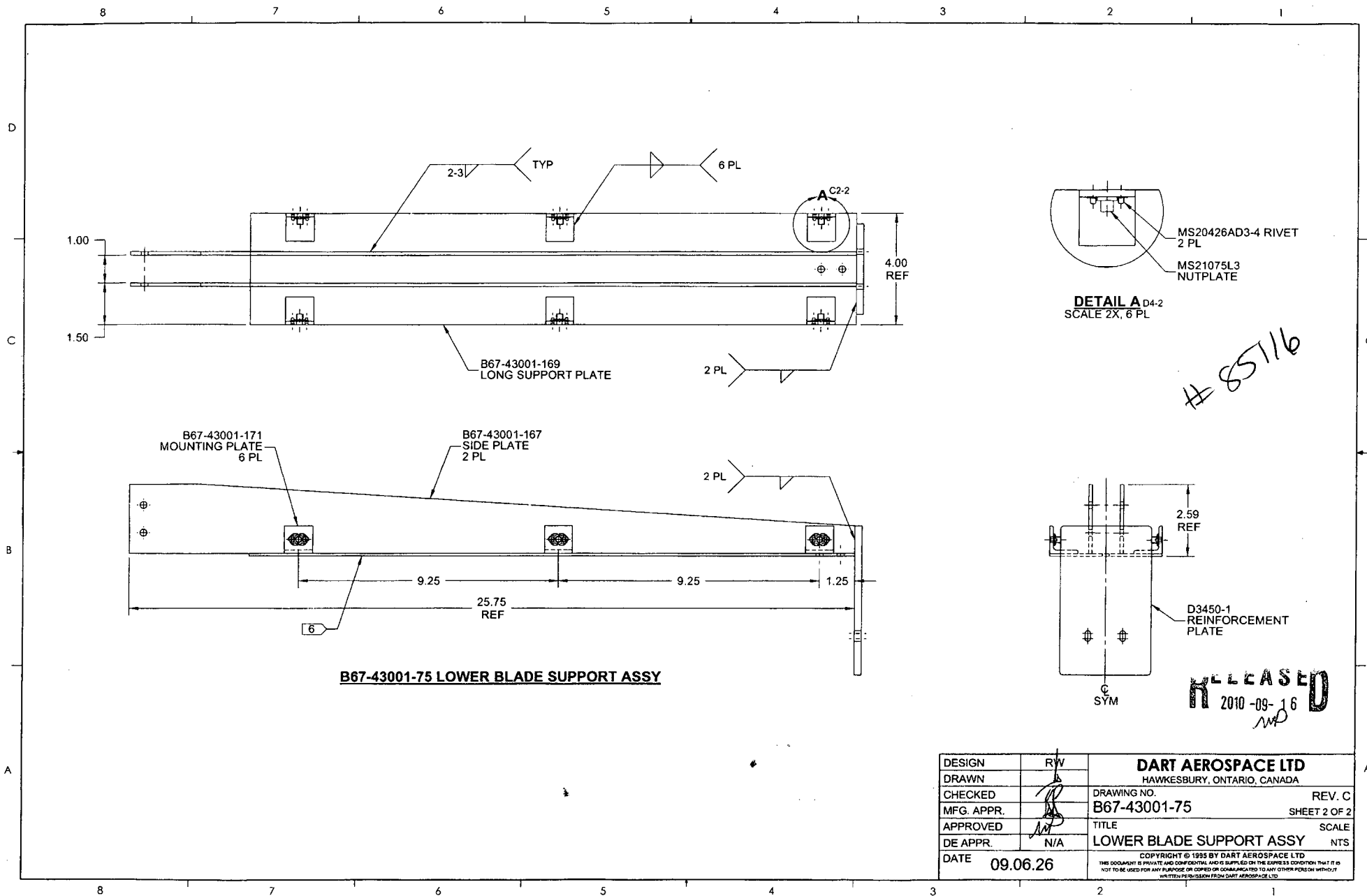
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-75	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	LOWER BLADE SUPPORT ASSY	NTS
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